

Work Order ID 53243

October 28, 2009 1:20:32 PM



Page 1

Item ID: PB67-43001-63

Accept



Setup Start



Revision ID: B1

Item Name: Handle Assembly

Stop



Start Date: 10/29/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 11/16/2009 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-10-28 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001	Rev B1

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- chamfer both ends (0.090") on -129 and -127 ☐ 2- chamfer (0.090") only the angle end on -157 ☐ 3- drill #40 hole in center of -129 before welding -131 caps, to let air out ☐ 4- weld -131 to -129 as per dwg ☐ 5- grind weld flush ☐ 6- assemb

10/11/30 Seq 100

② 09/11/27

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

② 09/11/30

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

→ 10/11/30

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

****mask only -157 starting from rivet to end of -157 tube, rivet must be powder

coat****☐START TIME:

☐OVEN TEMPERATURE:

☐FINISH TIME:

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

150

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1- assemble by drilling thru both -157 and -133 as per dwg ☐2- install spring slotted pin as per dwg

Add to Seq 100
09/11/30

09/12/30

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo N/A 09/11/30	0.00 0.00							
170 Packaging Packaging	Identify as per dwg & Stock Location: 449 Memo	0.00 0.00							10/9/12/2 (2)
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							09/12/03 JF -MK 09-12-02

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 53243

Parent Item: PB67-43001-63RevB1

Parent Item Name: Handle Assembly


Comments:

Start Date: 10/29/2009

Required Date: 11/16/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
240-107  SPRING SLOTTED PIN		Purchased	No			150	Each	74.0000	2.0000			

Pl 09/11/27

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

74

112813

74

CR3213-4-2

Purchased

No

150

Each

4.0000

2.0000



Cherry Rivet

(2) ✓

Pl 09/11/27

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

4

102569

4

PB67-43001-127RevB1

Manufactured

No

100

Each

4.0000

2.0000



Handle Arm

(2) ✓

Pl 09/11/27

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

4

43327

4

(2) ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 2

Work Order ID: 53243

Parent Item: PB67-43001-63RevB1

Parent Item Name: Handle Assembly

Comments:

Start Date: 10/29/2009

Required Date: 11/16/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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PB67-43001-129RevB1 Manufactured No



Tube Handle

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

5

45002

5

100

Each

14.0000

4.0000

② ✓

10/29/11/27

PB67-43001-131RevB1 Manufactured No



Tube End Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

14

45770

14

150

Each

6.0000

2.0000

④ ✓

10/29/11/27

PB67-43001-133RevB1 Manufactured No



Clevis

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

6

45001

6

② ✓

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

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Parent Item: PB67-43001-63RevB1

Parent Item Name: Handle Assembly


Comments:

Start Date: 10/29/2009

Required Date: 11/16/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
PB67-43001-137RevB1		Manufactured	No			100	Each	3.0000	2.0000			
												
Locking Sleeve												

Cpl 09/11/27

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

3

44999

3

PB67-43001-157RevB1

Manufactured No

100

Each

3.0000

2.0000



Tube

② ✓

Cpl 09/11/27

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

3

43390

3

② ✓

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Shop Packet Print

Page 3

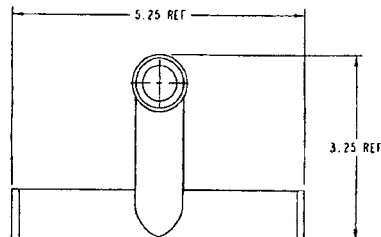
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

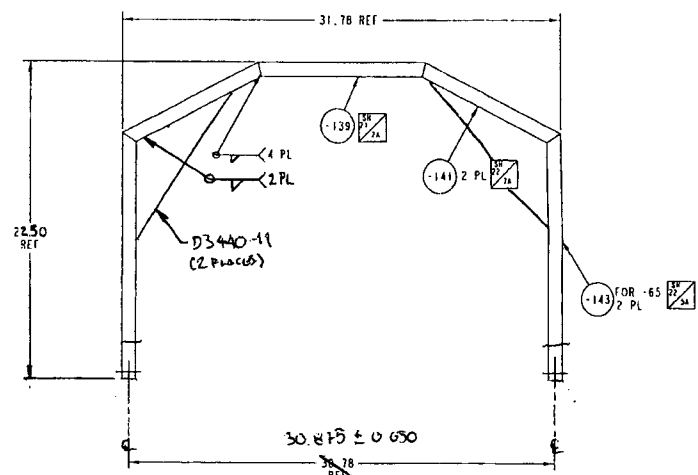
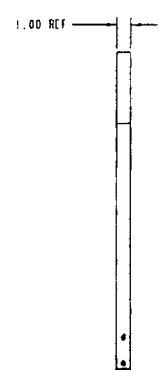
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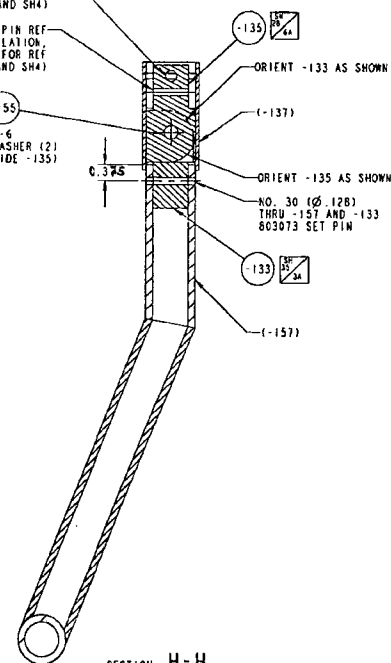
#53243



(CL-40-SBP-3 DETENT REF
LOCATE AT INSTALLATION.
SHOWN HERE FOR REF
SEE DWG SH3 AND SH4)

(80373 SET PIN REF
LOCATE AT INSTALLATION.
SHOWN HERE FOR REF
SEE DWG SH3 AND SH4)

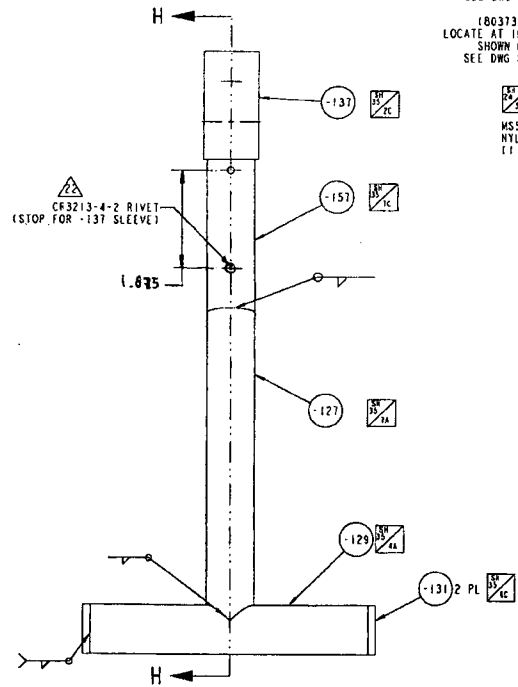
MS1859-6
NYLON WASHER (2)
(1 EA SIDE -135)



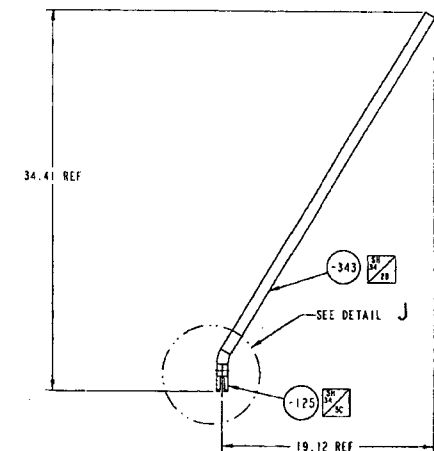
RELEASED
06 w. 2w

① -63 BASE ASSEMBLY (SHOWN)
(COMMERCIAL VERSION)
SCALE 0.250

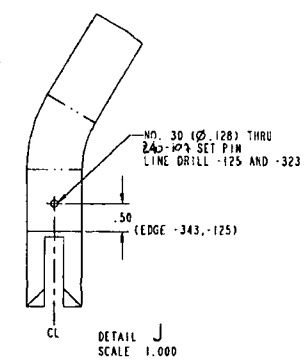
① -47 BASE ASSEMBLY (SAME, EXCEPT AS SHOWN)
(CANADIAN VERSION)



① -63 SHORT T-HANDLE ASSEMBLY
SCALE 1.000



① -37 TUBE ARM ASSEMBLY
SCALE 0.200



DETAIL J
SCALE 1.000

PREMIER AVIATION, INC.
2000 Aviation Parkway, Grand Prairie, Texas 75050

DATE	CODE	IDENT	NO.	DWG	NO.	REV.
01	05	08	8	B67-43001	61	1
SCALE: 1:1						15 x 25

ORIGINAL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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